

Date: Thursday, 6/7/2007 3:34:27 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 32876	
Estimate Number : 12322	
P.O. Number : <u>N/A</u>	Part Number : D3492041
This Issue : 6/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3492 REV B
Prsht Rev. : <u>NC</u>	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 32598	Material : <u>N/A</u>
Written By : _____	Due Date : 6/26/2007 Qty: 40 Um: Each
Checked & Approved By : <u>0706.08</u>	
Comment : est rev A 06.03.03 New Issue EC	
Est Rev:B 06-08-28 As per Rev B JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)  
 6061-T6 Round Bar .625" 17104598  
 (M6061T6R0625) 11061598  
 Batch: 1104619

58 / 20 07/06/22

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492  
 Dwg Rev: B  
 Folio Rev: ΔΔ

DIP 07/06/23 (40)

88 / 20 07/06/22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 07/06/23 (40)

88 / 20 07/06/22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

88 07.06.23

(40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

mul 07/06/26 x40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:34:27 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 32876

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



COUNTED.

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ess

07-06-28

40x

7.0

POWDER COATING

POWDER COATING



M1104144



40x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

m-l

07/06/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FSI

07/07/03

40

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Qty Part Number Description

Batch

1 NAS1611-010 O-RING

M1103500

14x

07/07/03

M1103272

26x

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



40x

Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: M1101223

m-l

07/07/03

11.0

QC5

INSPECT WORK TO CURRENT STEP



m/ 070703



40

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



40x

Comment: PACKAGING RESOURCE #1

FP-16

m-l

07/07/03

13.0

QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

07/07/03

Job Completion



07-07-03

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

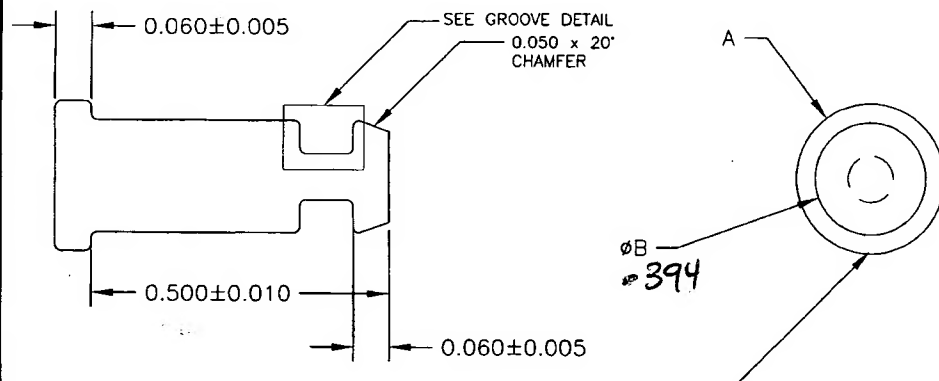
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

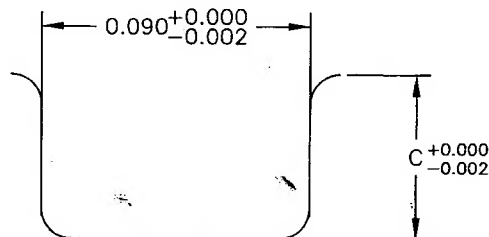
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

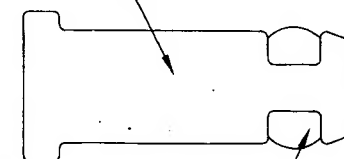


D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

UNCONTROLLED  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 328740  
 ENG'D  
 RET  
 SHIP COPY

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED  
 06.10.04 PH  
 P/N: ECU #351

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING



B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.05.11	
DRAWING NO. D3492		TITLE PLUG
DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B SHEET 1 OF 1 SCALE NTS

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